	Work Orde May 1, 2013 7:2		0803		*1008	303*		`		Page I	
R	tem ID: Revision ID: tem Name:	D2345  Lock Channel	D 2345	3	Accept	* <b>N</b> 900040	100*	Setup	Start Stop	*NS1* *NS2*	
Ŗ	tart Date: Required Date: Reference:	4/30/13 4/30/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item ID: Customer:					
	Approvals:	Process Plan	n: <b>/</b>	Date: <i>13-05-/</i>	Tooling: SPC (Y/N):	Date: Qate:			Start Stop	*NR1* *NP2*	
] • <b>V</b>	oge. 2 Vork cente. 1. Draw Nbr	Revi	Tation Liscription sion Nbr		Kun Libbis	ff gr	Fian Acce Cone Qty	et Rejc Qty		eject sp. umber Stamp	
i d	D2345 00 *1100* Waterjet LOW CNC Waterje	et	FLOW WATER JET		0.00  0.00  A Prog Rev: A	_ 2-			ø	Ae 13.01.	28
1 •	<b>304 - 05</b> 7 10 <b>* 110*</b> QG Qd Qdality Control		QC2- Inspect parts off i	machine FAI/FAIB	0.00				ø	Au 13.57	7.28
4	<sup>20</sup> * <b>12</b> 0*		QC8- Inspect parts - sec	cond check	0.00		C	ÍS) 12	5.07.	\a	)AS

Quality Control

(5) 13.07.29

											DQA:	Date	:	
NCR: Y	es	/ No				<b>WORK ORDER NON-C</b>	CON	<b>VFORM</b>	MANCE / UPDATE		·			
											QA Closed:	Date	:	
Work Orde	r:					DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No	o					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite			Pro Rec/Stor	Engineering Quality Other		
Root			Descr	iption of work order update		nitial	Action		Sign &		· · · · · · · · · · · · · · · · · · ·			
Cause	١	Date	Step	Qty		or Non-conformance		ief Eng	Description		Date	Verification	QC Inspector	
oc/Data											-			
quip/Tooling														
perator					:									
//aterial														
etup														
Other							1							
rocess	_													
upplier	_						ı							
raining	_						ļ	,				-		
inapproved	丄													
						F.	AUL	T CATE	GORY					
Landin	_				_	General	_	1				_	<b></b>	
ļ	_	Bending			L	Bend		Grain			Ovalized		Pressure/Forced	
		Centre No	t Concer	ntric to	o/s	BOM/Route	<u> </u>	Hardwa			Over/Under	<b>)</b> —	Temperature/Cure	
ļ.	_	Cracks			-	Broken/Damaged	$\vdash$	4	ion Incomplete		Part Incorred	<u> </u>	Weld	
	_	Crushed/0	Crimped		<u> </u>	Burrs	<u>_</u>	4	ions Incomplete/Unclear	Щ	Part Lost/Mi	ssing	Wrong Stock Pulled	
1	Cuffs			Contamination	$\vdash$	Mainte			Part Moved					
1	Heat Treat			Countersink	1	Mislabe		$\vdash$	Positioned V	· ·	ا ا			
		Inspection		Tube	L	Cut Too Short	$\vdash$	Misread	d	L	Power Loss/	Surge	Other	
1	_	Ripples in	Bend	ឆ្កា	100	Drill Holes	$\vdash$	Offset						
					100		-	4	Calibration					
	-	Turning S			5 3 \$ 4	Finish	-	-1	Sequence					
ļ	ı	Wave/Tw	ist in Tub	oe .		Folio		Outside	Dimensions					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

## Work Order ID 100803

May 1, 2013 7:21:31 AM

\*100803\*

Item ID: D2345 Revision ID:

Accept \*N900040100\* Setup Start \*NS1\*

\*NS2\*

Lock Channel Item Name: Start Date:

Start Qty: 8.00 4/30/13 Required Date: 4/30/13 Req'd Qty: 8.00

\*8\* \***Q**\*

**Cust Item ID: Customer:** 

Date:

Date:

Reference:

Small Fab

\*140\*

Brake NC

Brake NC

140

150

Approvals: **Process Plan:** Date: **Tooling:** OC: SPC (Y/N): Date: 4.368 July JB/ Work Center 12 Lescription Kun hours 130 0.00 Small Fab \*130\* Small Fab 0.00 Memo

Same

Deburr if necessary. 0.00 NC BRAKE 0.00 Memo Form as per Dwg D2345 using DT8241

QC5- inspect part completeness to step on W/O 0.00 0.00 Memo

Start \*NR1\* Run

Reject

Number

Accept

Qty

ú asuka

Cod

Reject

**Qty** 

FF 13-07-30

Samp

15 Ø

(5) 13.07.30



Quality Control

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-	CON	<b>IFORN</b>	AANCE / UPD	ATE			
										QA Closed:	Date:	
Work Orde	ŕ:				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part N					Rework Scrap Use-as-is		f	Skid-tube Machining Moforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	0	·			Work Order Update		Large Fab Composite		Composite	]	Supplier	
Root		1		Descri	ption of work order update	1	nitial	Actio	on	Sign &	12	
Cause	Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC inspector
Doc/Data												
quip/Tooling						1						
Operator												
Material						1						
Setup							1					
Other												
Process							1					
Supplier							ı					
raining [							Í					
Jnapproved		<u> </u>			<u>.</u>							
			-		F	AUL	T CATE	GORY			- 1	
Landin	g Gear		F. v	~	General	. !-	•	***	in the second	<b>-</b>	9.7	<u>.</u> (t
	Bending				Bend		Grain			Ovalized	<u>.                                    </u>	Pressure/Forced
	Centre N	ot Conce	ntric to (	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct	Weld
Į	Crushed/	Crimped		L	Burrs		instruct	ions Incomplete/U	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	enance		Part Moved		
	Heat Treat		Countersink		Mislabe	eled		Positioned V	Vrong	_		
	Inspectio	n Strip in	Tube		Cut Too Short		Misread	t .		Power Loss/	Surge	Other
	Ripples in	n Bend			Drill Holes		Offset					
	Torque V	Vaves in I	Extrusio	n [	Drawing		Out of (	Calibration				
	Turning S	Sequence	!		Finish		Out of 9	Sequence				
	Wave/Tv	vist in Tul	be		Folio	Outside Dimensions						

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

May 1, 2013 7:21:31 AM

Item ID:

D2345

**Revision ID:** 

**Start Date:** 

Item Name:

Lock Channel

4/30/13

Start Oty: 8.00

Reg'd Oty: 8.00

\*8\*

\*8\*

Accept

\*N900040100\*

Setup Start \*NS1\*

\*NS2\*

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Required Date: 4/30/13

**Process Plan:** OC:

Date: Date:

SPC (Y/N):

Tooling:

Date:

Date:

Run Stop

Smuence iD/

Work Center ID

\*160\* Packaging

Packaging

Oneration Description

Identify as per dwg & Stock Location: GA

Run Hours

Set Up/

0.00

0.00

Too!#

Plan Code

Accept Oiv.

Reject Reject Oty Number Stamp

15

13-07-31 fB

170

\*170\*

OC. Quality Control OC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

MLS 13-07-31

									DQA:	Date:		
NCR: Ye	s / No				WORK ORDER NON-C	ONFOR	QA Closed:	Date:				
Work Order:					DISPOSITION AGAINST (				DEPARTMENT/PROCESS			
Part No NCR No	· · · · · ·				Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite			Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root			,	Descri	ption of work order update	Initial	Ac	ction	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector	
Doc/Data								· ·				
Equip/Tooling												
Operator												
Material					•							
Setup		1										

Landin	g Gear	General		_	_		
	Bending	Bend		Grain	Ovalized		Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance		Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect		Weld
[	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing		Wrong Stock Pulled
	Cuffs	Contamination	Г	Maintenance	Part Moved		_
[	Heat Treat	Countersink		Mislabeled	Positioned Wrong		
	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge	Г	Other
[	Ripples in Bend	Drill Holes	Г	Offset	-		
). " [	Torque Waves in Extrusion	Drawing		Out of Calibration			
	Turning Sequence	Finish		Out of Sequence			
	Wave/Twist in Tube	Folio		Outside Dimensions			

**FAULT CATEGORY** 

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Other Process Supplier Training Unapproved Work Order ID:

100803

Rarent Item:

D2345

Parent Item Name:

Lock Channel

Comments:

IPPRevB99.05.31Re-formatDM

IPP Rev:C Now on Waterjet 06-10-26 JLM

	in interior from	on material of the	0 <b>2</b> 0 5E										
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA 304/316 .050 Sheet		Purchased	No			100	sf	287.6699	0.0528	0.4446312	, 8	Au	
			. 8	Location		Loc Qty	Lo	c Code				13.0	7.28
				N. N. T.		٠.							w.
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				1 . /	/60	5							1,211 (4)
. \	•			120	604	5							
				122	325	3							
				123	155	3							
				124	572	172.3							
54				MAT020		94.369894							
r j				120	243	2				_			
				121	626	1.529894				<del></del>			
•				.124	029	90.84			12	4029			

Page 1

Required Date: 4/30/13

Required Qty: 8.00

**Start Date:** 4/30/13

Start Qty: 8.00

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NCR: Ye	$oldsymbol{\cdot}$											
										QA Closed:	Date	•
Work Order:	:				DISPOSITION			AGAINST	DEP	ARTMENT/	PROCESS	
Part No	). 				Rework Scrap Use-as-is		Skid-tube Crosstube Machining Small Fat Thermoforming Finishing				Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR No	)		<del></del>		Work Order Update	<u> </u>	Large Fab Composit			nec/stor	Supplier	
Root				Descri	ption of work order update	Initi	ial	Action		Sign &		
Cause					or Non-conformance	Chief	Eng	Description		Date	Verification	QC Inspector
oc/Data	_							,				
quip/Tooling									- 1			
perator							ļ		Ì			
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Other	er 🔲					Ì						
rocess		i				İ						
upplier									ļ			
raining	_					1						
Inapproved							1				<u> </u>	
						AULT C	CATE	GORY				
Landing				_	General			ſ			_	¬
<u></u>	Bending			<u> </u>	Bend	<b>—</b>	rain		⊢⊣	Ovalized	. <b>-</b>	Pressure/Forced
L	Centre N	ot Conce	ntric to (	o/s	BOM/Route	$\blacksquare$	irdwa		$\boldsymbol{\vdash}$	Over/Under	<b>⊢</b>	Temperature/Cure
<u> </u>	Cracks			Broken/Damaged		•	on Incomplete	ш	Part Incorrect		Weld	
L	Crushed/Crimped		Burrs	-		ions Incomplete/Unclear	$\vdash$	Part Lost/Mi	ssing	Wrong Stock Pulled		
L	Cuffs			Contamination	<u> </u>		nance	$\vdash$	Part Moved			
L	Heat Trea			_	Countersink	$\vdash$	islabe		-	Positioned W		7045
<u>_</u>	Inspectio		Tube	<u> </u>	Cut Too Short	$\vdash$	isread		Ш	Power Loss/	Surge	Other
	Ripples in			<u> </u>	Drill Holes	$\vdash$	ffset					
L	Torque V			¹	Drawing	-		Calibration	٠.			
1	Turning 9	Sequence		ŀ	Finish Out of Sequence							

Outside Dimensions

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

DART AEROSPACE LTD	Work Order:	100803
Description: Lock Channel	Part Number:	D2345
Inspection Dwg: D2345 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing	Ţ <u> </u>					
_	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension		Dimension			Inspection	
2.800	+/-0.010	2.800	<b>-</b> .		V	JKm-01
2.520	+/-0.010	2.52 ပ			V	
Ø0.094	+0.004/-0.001	86	_		V	
0.478	+/-0.010	, 478	_		V	
1.256	+/-0.010	1.256	-		V	
Ø0.197	+0.005/-0.001	. 196	-		V	
2.750	+/-0.010	2.150	_		V	
3.000	+/-0.010	2.999	_		V	
0.050	+/-0.010	.048	_		V	
			- "			
						7.0
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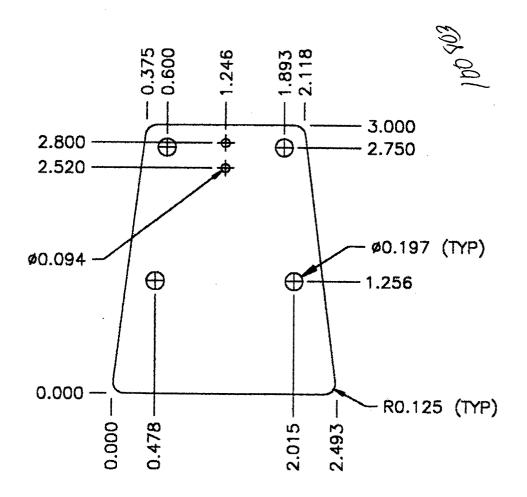
Measured by:	Audited by: 09	Prototype Approval:	N/A
Date: 13.07.28	Date: 13.07-29	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.11.20	New Issue	KJ/JLM	
			- X	





DESIGN B WILLIAMS	drawn by B Williams	DART AEROSPACE VICTORIA INTERNATIONAL AIRPORT,		*******	
CHECKED	APPRICIVED	DRAWING NO.	***************************************	REY.	$\overline{\lambda}$
BW -	VL .	D2345	SHEET	2 OF	2
DATE	<i>*</i>	IIILE	·	SCA	匩
95:02:21		LOCK CHANNEL		1	1:1

## RELEASED MADE OF THE DESCRIPTION 


D2345 FLAT PATTERN MATERIAL: 304/316 SS 0.050 THICK